

Work Order ID 78731

Thursday, January 12, 2012 4:27:53 PM

78731

Page 1

Item ID: D3372-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Collective Lock Assembly

Start Date: 1/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/16/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MC*Date: *12-01-12* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3372	Rev B

100 0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
Identify as D3372-3

110

QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

0.00

Quality Control

120

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as
D3369-5*Ship Monday
Alike**12/01/13* *(C)**Ss 12/01/13**(C)**Ss 12/01/13**(C)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78731

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Item ID: D3372-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Collective Lock Assembly

Stop ***NS2***

Start Date: 1/12/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/16/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

8/12/13

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	1119713

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Large Fab

Tack weld lock shaft as per Dwg D3372

A/R	SS Rod	Batch
		1114509

12-7-13 (X1)

Work Order ID 78731

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Item ID: D3372-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Collective Lock Assembly

Start Date: 1/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/16/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

PC12-01-16 (1x)

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Size 1/16

PC

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

Size 1/16

Picklist Print

Thursday, January 12, 2012 4:27:52 PM

Page 1

Work Order ID: 78731

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 1/12/2012

Required Date: 1/16/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
 IPP Rev:B Added Key ID _____ 06.03.21 EC
 10.05.13 verified :EC
 IPP Rev:C added D3384-043 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	892.0000	2	2		12/01/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST377		592							
				119343		592							
				ST522		300							
				120208		300							
AN5-42A Bolt		Purchased	No			100	Each	35.0000	1	1		12/01/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST340		35							
				108442		15							
				119438		10							
				119449		10							
AN960-416 Washer	NAS1149F0463P	Purchased	No			100	Each	0.0000	2	2		12/01/14	
D2728-7 Dart Logo label		Manufactured	No			100	Each	0.0000	0	0		12/01/14	
D3372-1 Main Body		Manufactured	No			100	Each	9.0000	1	1		12/01/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST491		7							
				75202		7							
				ST492		2							
				75126		2							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 78731

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 1/12/2012

Required Date: 1/16/2012

Start Qty: 1.00

Required Qty: 1.00

D3372-5
Cam Lock Shaft

Manufactured No

100 Each 6.0000

1

SB 1 12/01/14

Location

Loc Qty

Loc Code

ST038

6

76485

6

D3372-7
Slider Body

Manufactured No

100 Each 6.0000

1

SB 1 12/01/14

Location

Loc Qty

Loc Code

ST492

6

75203

6

D3373-1
Cam Lock

Manufactured No

100 Each 70.0000

1

SB 1 12/01/14

Location

Loc Qty

Loc Code

ST039

70

58463

2

74862

19

75666

49

D3384-043
Cyclic Sock Assembly

Manufactured No

100 Each 4.0000

1

SB 1 12/01/14

Location

Loc Qty

Loc Code

ST484

4

77188

4

HX-81
1/4"-20 SHCS 3/8" long

Purchased No

100 Each 7.0000

1

SB 1 12/01/14

Location

Loc Qty

Loc Code

ST390

7

114383

7

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

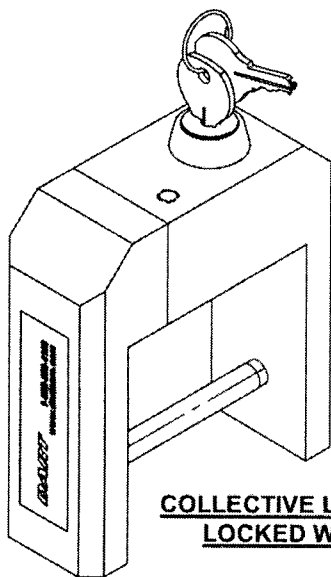
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

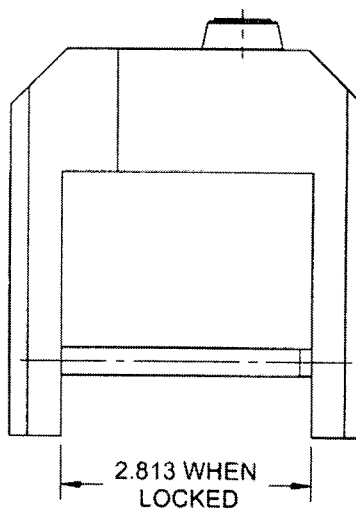
NOTE: Date & initial all entries



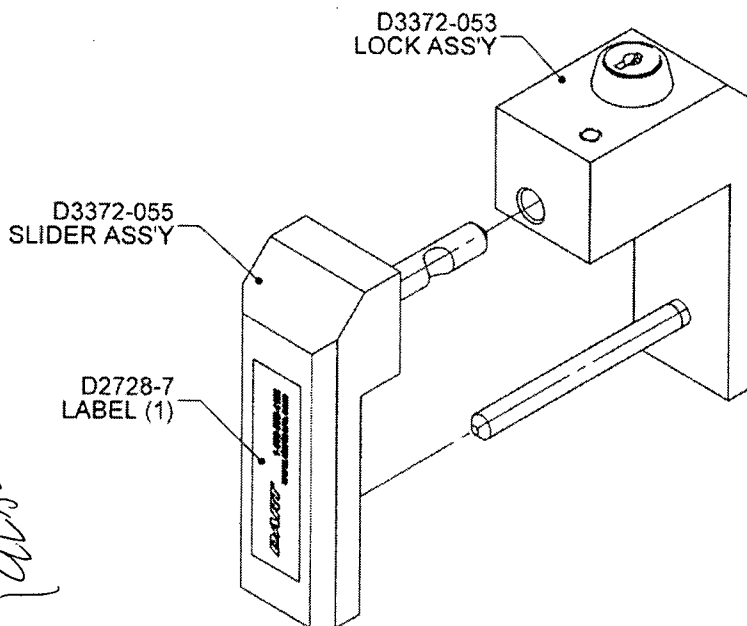
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



2.813 WHEN
LOCKED



RELEASED
[Signature]
05/04/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

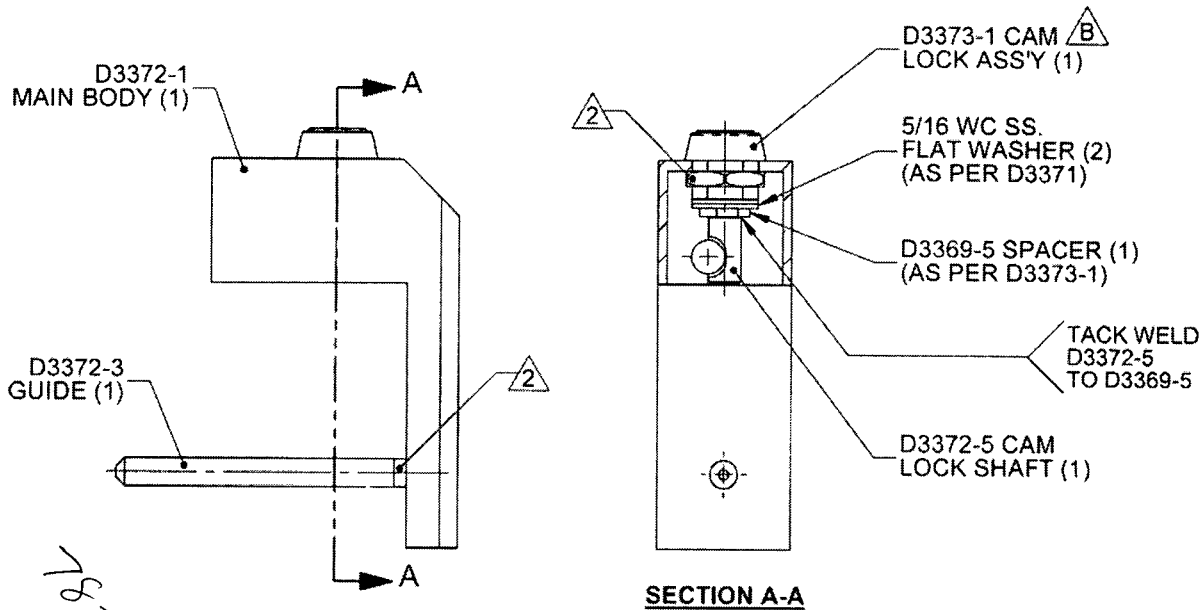
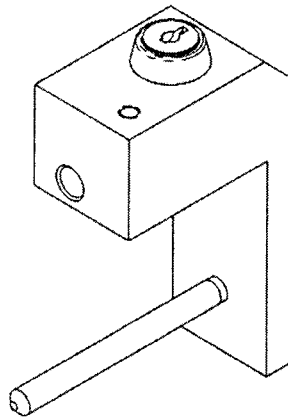
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DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

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25/04/23



D3372-053 LOCK ASS'Y

NOTES:

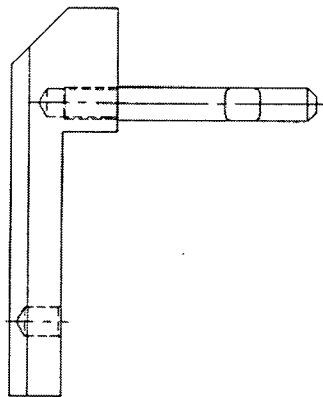
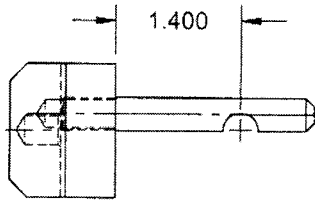
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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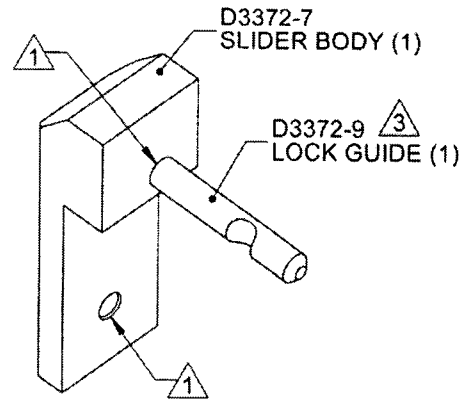
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



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[Signature]
05/04/23



16/12/1

D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

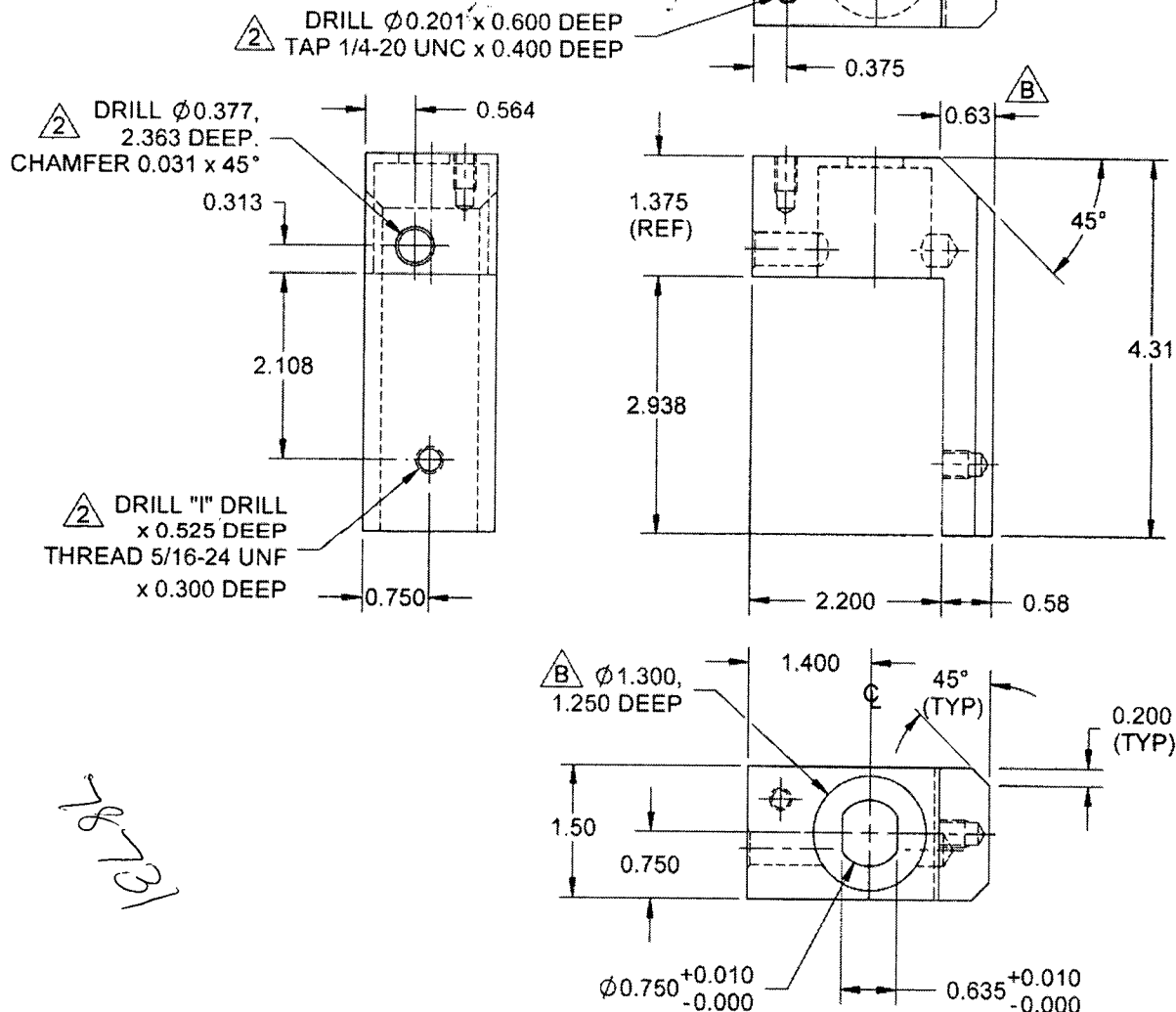
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DATE 05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2	

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05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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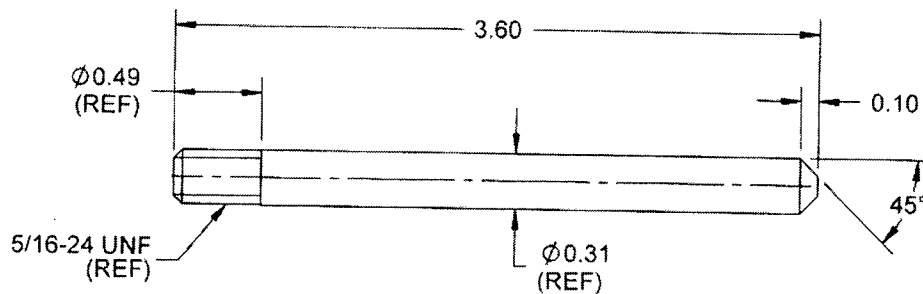
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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[Signature]
05/04/23



#1879

D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

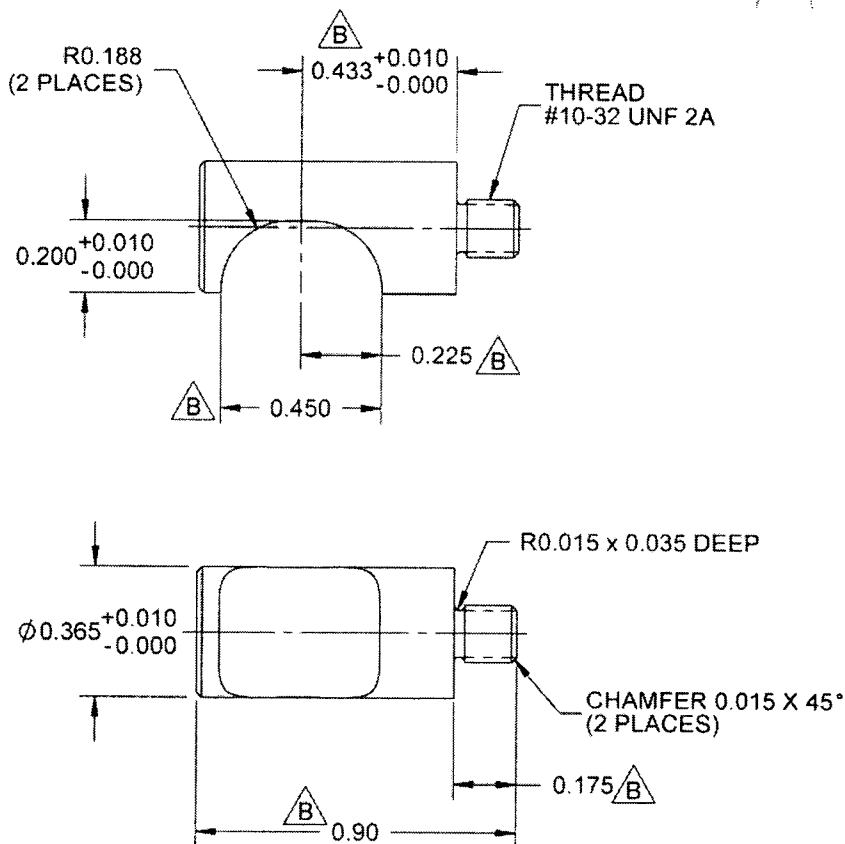
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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05/04/28



76721

D3372-5 CAM LOCK SHAFT

NOTES:

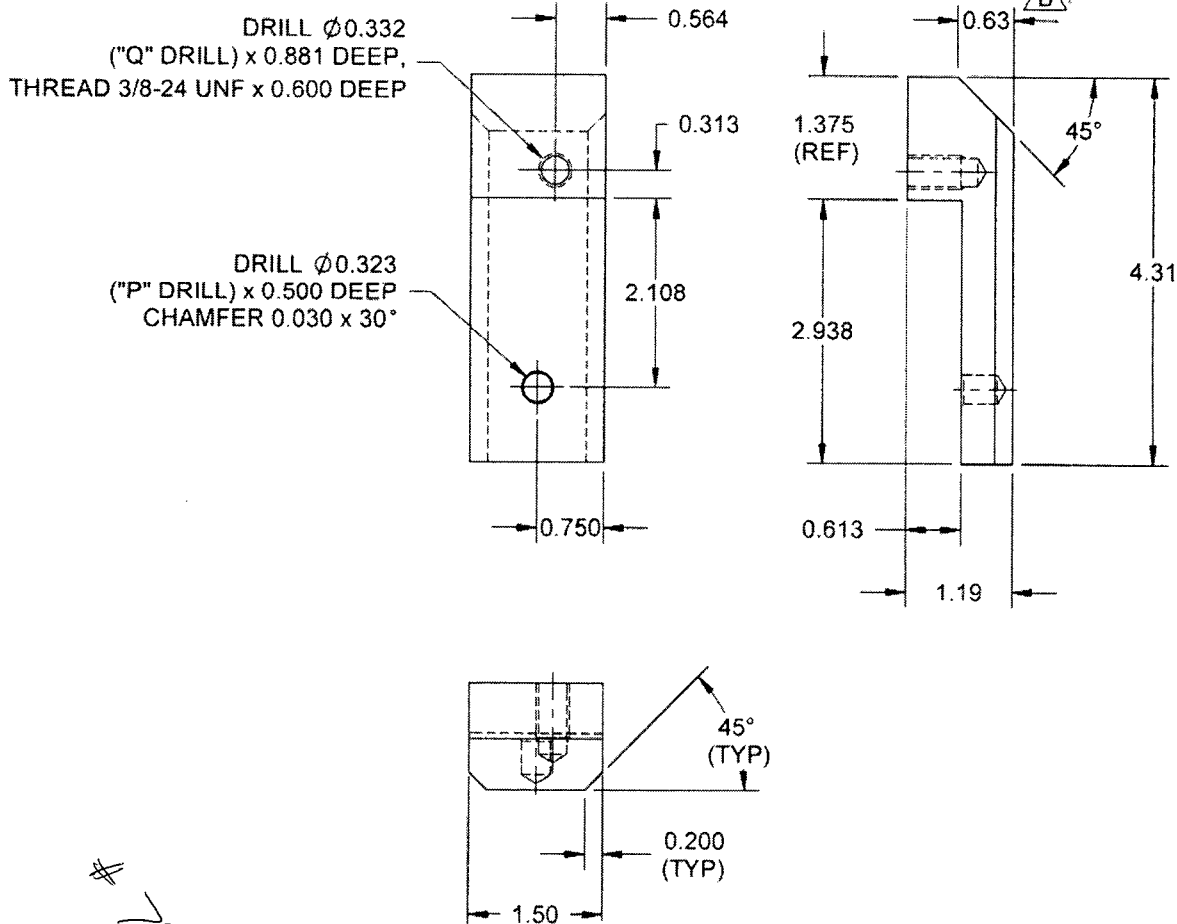
- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

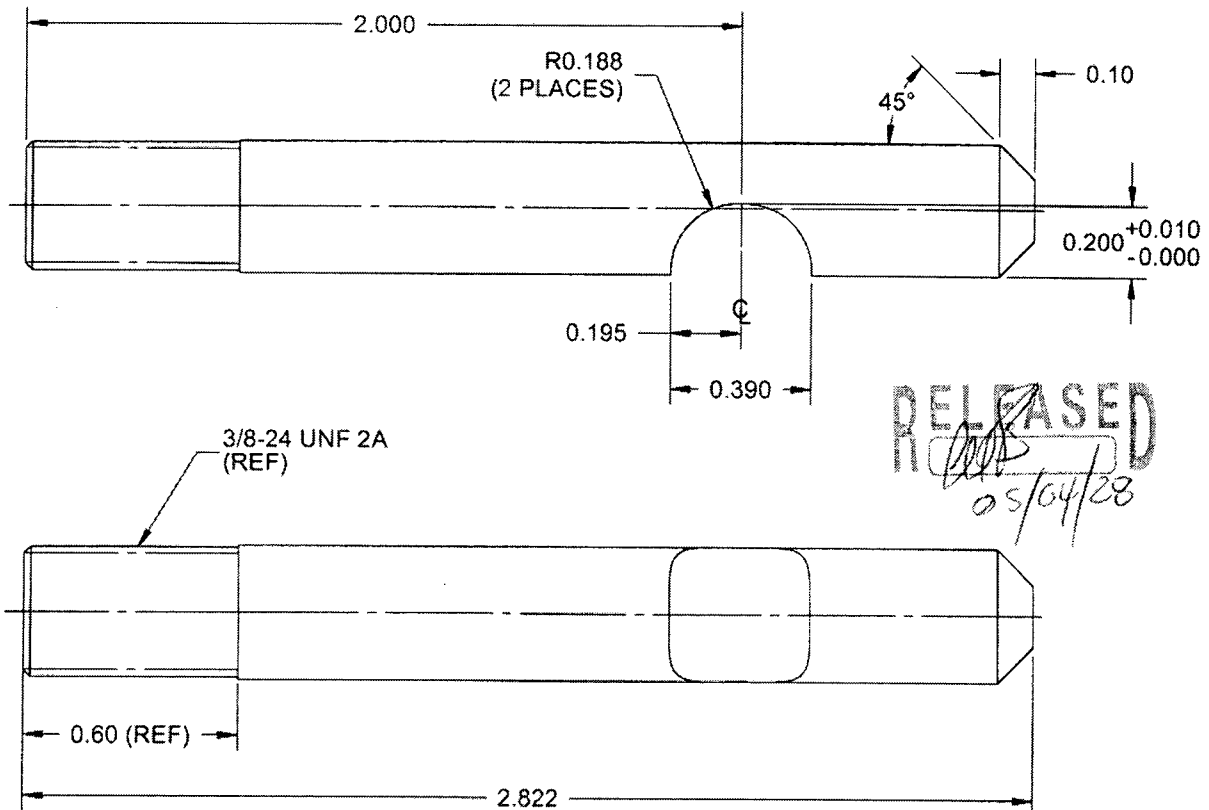
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



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[Signature]
05/04/23

19879

D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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